Quality Control

Work Orde Wednesday, Mark												Page 1
Item ID: Revision ID:	D3501-1			Accept					Setup			
	Bushing 3/30/2011 4/4/2011	Start Qty: 100. Req'd Qty: 100.			Cust Item II Customer:	D:				Stop		
Approvals:	Process Pla	nn:	Date://-03	ろいTooling: SPC (Y/N):		ite:	-	F		Start Stop		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje			Insp. Stamp
Draw Nbr	Rev	ision Nbr					x					
D3501	Rev	' A			·							
Hardinge CNC Lathe	e Small	Hardinge CNC LATH Memo		0.00 0.00 & DWG D3501 ,□FOLIO				ioe	4			
That amge of the Earlie	·	REV!	□DWG REV:	□2-DEBURR AS REQ	WB19							
110 		QC2- Inspect parts of	ff machine FAI/FAIB	0.00				160	#)		
Quality Control					,19							
		QC8- Inspect parts - s	second check	0.00	U. 6.9	ŕ		1000	9	A		
QC		Memo		0.00								

W/O:		WORK ORDER CHAN	WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
	~						į						
•													
Part No)•	PAR #: Fault Category:	NCB: Va	s No DO	Δ.	Date:							

QA: N/C Closed: _____ Date: ____

Resolution: _____ Disposition: _____

NCR:			WORK ORD	ER NON-CONFO	RMANCE	(NCR)			
	T	Description of NC		Corrective Action	Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descript Chief Eng	ion	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 67757

Wednesday, March 30, 2011 10:32:40 AM



Page 2

Item ID:

D3501-1

Accept



Setup Start



Revision ID:

Item Name:

Bushing 3/30/2011

Start Date:

Start Qty: 100.00

Required Date: 4/4/2011

Req'd Qty: 100.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Stop



QC:

Date:

SPC (Y/N):

Set Up/

Date:

Accept

Reject

Insp.

Sequence ID/ **Work Center ID**

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: 63

0.00

0.00

Run Hours

Tool# Plan Code

Qty

Reject Qty

Number

Stamp

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

MC 106-10

Dart Aerospace Ltd

W/O:		WORK ORDER CH	ANGES					-
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			L					

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	:	Date:
Resolution:		Disposition:	 QA: N/C Closed:		Date:

NCR:		•	WORK ORDE	ER NON-CONFO	RMANC				
		Description of NC		Corrective Action	Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng		ion	Sign & Date	Section C	Chief Eng	QC Inspector
							j		

Picklist Print

Wednesday, March 30, 2011 10:32:46 AM

Work Order ID: 67757

Parent Item:

D3501-1

Parent Item Name: Bushing



Start Date: 3/30/2011

Required Date: 4/4/2011

Page 1

Start Qty: 100.00

Required Qty: 100.00

Comments:

IPP Rev:A New Issue 06-05-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No		-	100	f	65.2100	0.0791	8.326316			
										SY	11/9	29	

303 Round Bar 0.750

 Location
 Loc Oty
 Loc Code

 MAT028
 65.21

 117142
 65.21

241

6:1

117481

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Dart Aerospace Ltd

W/O:	•	WORK ORDER CH	ANGES					
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Dart No		DAD # . Foult Category:	NC.	D. Voc	No DO	\.	Data	

Part No: _		PAR #:	Fault Category:	 NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Close	d:	Date:

NCR:			WORK ORD	ER NON-CONFO	RMAN	CE (NCR)				
		Description of NC		Corrective Action	Section B	-	Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Descript Chief Eng	ion	Sign & Date	Section C	Chief Eng	QC Inspector	
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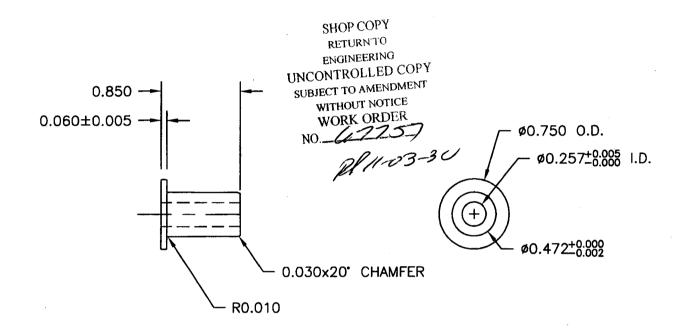
DART AEROSPACE LTD	Work Order:	47757
Description: Bushing	Part Number:	D3501-1
Inspection Dwg: D3501 Rev: A		Page 1 of 1

		FIRST AF	RTICLE INSP	ECTION (CHEC	KLIST		
		X	First Article	F	rotot	ype		ı
Drawing Tolerance Dimension		Actual Dimension	Accept	Reje		hod of ection	Comments	
0	.850	+/-0.010	-848			8	1-8	
0	.060	+/-0.005	037					
Ø	0.750	+0.008/-0.001	0.150		,			
Ø	0.257	+0.005/-0.000	0,260					
Ø	0.472	+0.000/-0.002	0.472	/	_	84		
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Measured by: Audited by: Prototype Approval: N/A								N/A
		1116/9	Date:	٠ ٩	7		Date:	N/A
Rev	Date 06.10.27	Change New Issue					Revised by	Approved
							·	·····

Dart Ae	rospace	e Ltd									
W/O:				WORK ORDER CHANGES							
DATE	DATE STEP PROCE		CEDURE	EDURE CHANGE			Ву		Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: PAR #: Fault				Category: NCR: Yes No DQA: Date:							
Resolution: Dispo			osition: Date:								
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DATE	STEP	Description of NC Section A			-	ction B	O:	Verifi	cation	Approval Chief Eng	Approval QC Inspector
DAIL			Initia Chief E		Action Description Chief Eng		Sign Date		ion C		
											
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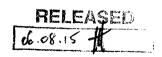


	DESIG	P	DRAWN BY		AEROSPACE LTD (ESBURY, ONTARIO, CANADA
I	CHECK	(ED M	APPROVED I	DRAWING NO.	REV. A
ı		#	1	D3501	SHEET 1 OF 1
I	DATE			TITLE	SCALE
	06.04.18			BUSHING	1:1
	Α		06.04.18	NEW ISSUE	



D3501-1 BUSHING

- 1) MATERIAL: AISI 303 SS (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL UNMACHINED SHARP CORNERS 0.010 MAX
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES



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Dart Ae	rospace	Ltd .								
W/O:				WO	RK ORDER CHANGES					
DATE	STEP	PROCEDURE		CHAN	GE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			-		·					
Part No: PAR #: Fault			Category: NCR: Yes No DQA: Date:							
Resolution: Dispo				osition: Date: Date:						
NCR:			WORK (RDE	R NON-CONFORMANO	CE (NCF	R)			
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DATE	STEP		Initia Chief E		Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspecto
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